

Work Order ID 140970

Tuesday, January 26, 2016 3:17:00 PM

647.7601

B140970

140970

Page 1

Item ID: 647.7601

REV. N/C

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lower Deflector Assembly

Start Date: ~~1/26/2016~~ 5/2/16 Start Qty: 2.00Required Date: ~~1/26/2016~~ 5/3/16 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: MCS

Date: JAN 28 2016

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.7600	NC

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

120

0.00

120

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 5.

A/R RTV LOCTITE 598:

exp. date: 09/17

134524

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

DAS
36
9-89

JUN 27 2016

DAS
36
9-89DAS
36
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 140970

Tuesday, January 26, 2016 3:17:00 PM

140970

Page 2

Item ID: 647.7601 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Deflector Assembly
 Start Date: 1/26/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/26/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>GA</u>	0.00			DAS 30 9-89	2			JUN 27 2016
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

GA 6/27/16

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Tuesday, January 26, 2016 3:16:59 PM

140970

647 7601

Required Date: 1/26/2016

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 15-08-04 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7611		Manufactured	No				Each	0.0000		2			
647 7611							B 141 032		**	(2) DAS 36 9-89		16/06/27	
Lower Deflector													
647.7612		Manufactured	No				Each	11.0000		2			
647 7612									**			DAS 6 9-89	
Breakaway Tip													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				CCK113			11						
				136947			1						
				138616			10						
MS20470AD6-14		Purchased	No				Each	311.0000		4			
MS20470AD6-14									**			DAS 6 9-89	
Rivet				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST308			311						
				m130741			4						
				m133284			307						

APR 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

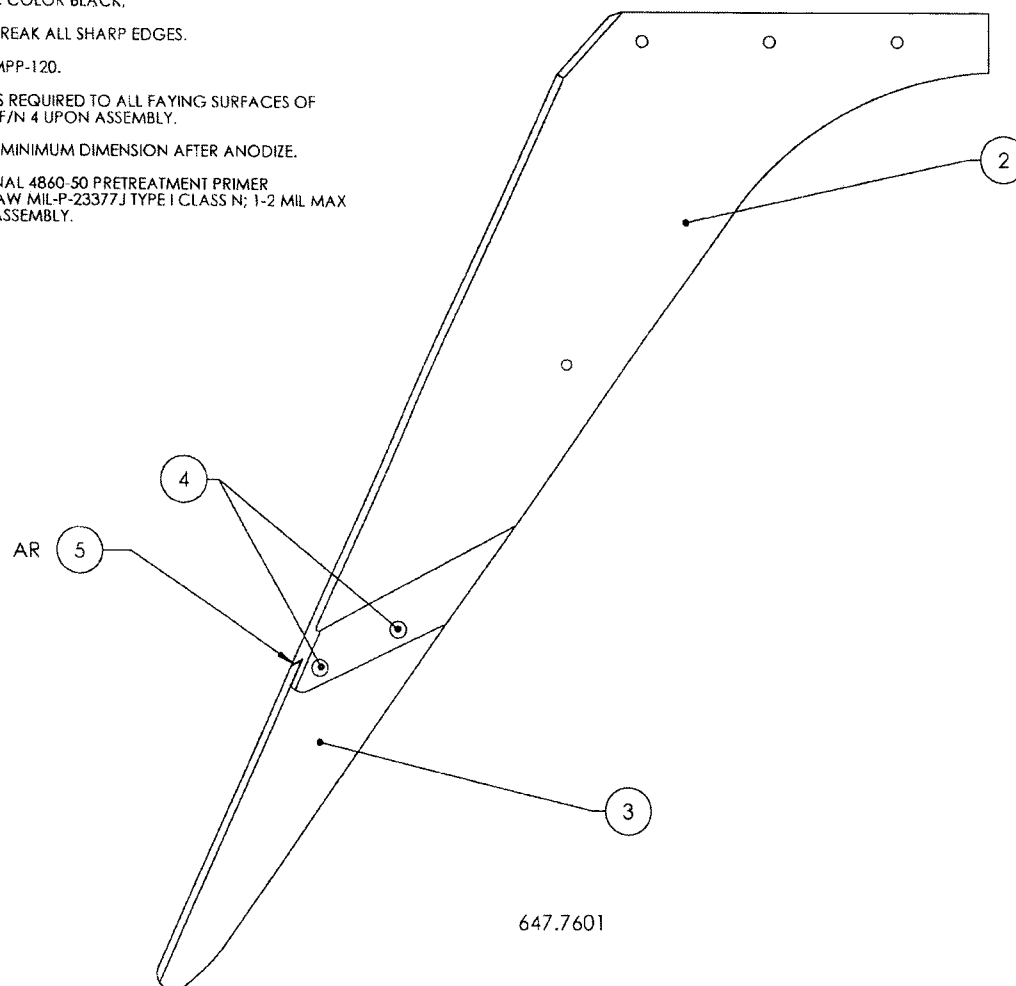
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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				Lead hand / Supervisor Approval Verification	
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OTHER : ☐					

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION: PPS		N/C
N/C	INITIAL RELEASE	12-02-09	P. BRAYC

NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2, F/N 3 & F/N 4 UPON ASSEMBLY.
- 6 MAXIMUM OR MINIMUM DIMENSION AFTER ANODIZE.
- 7 FINISH: CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX AFTER ASSEMBLY.



STOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
140.978 MLJ
16-01-28

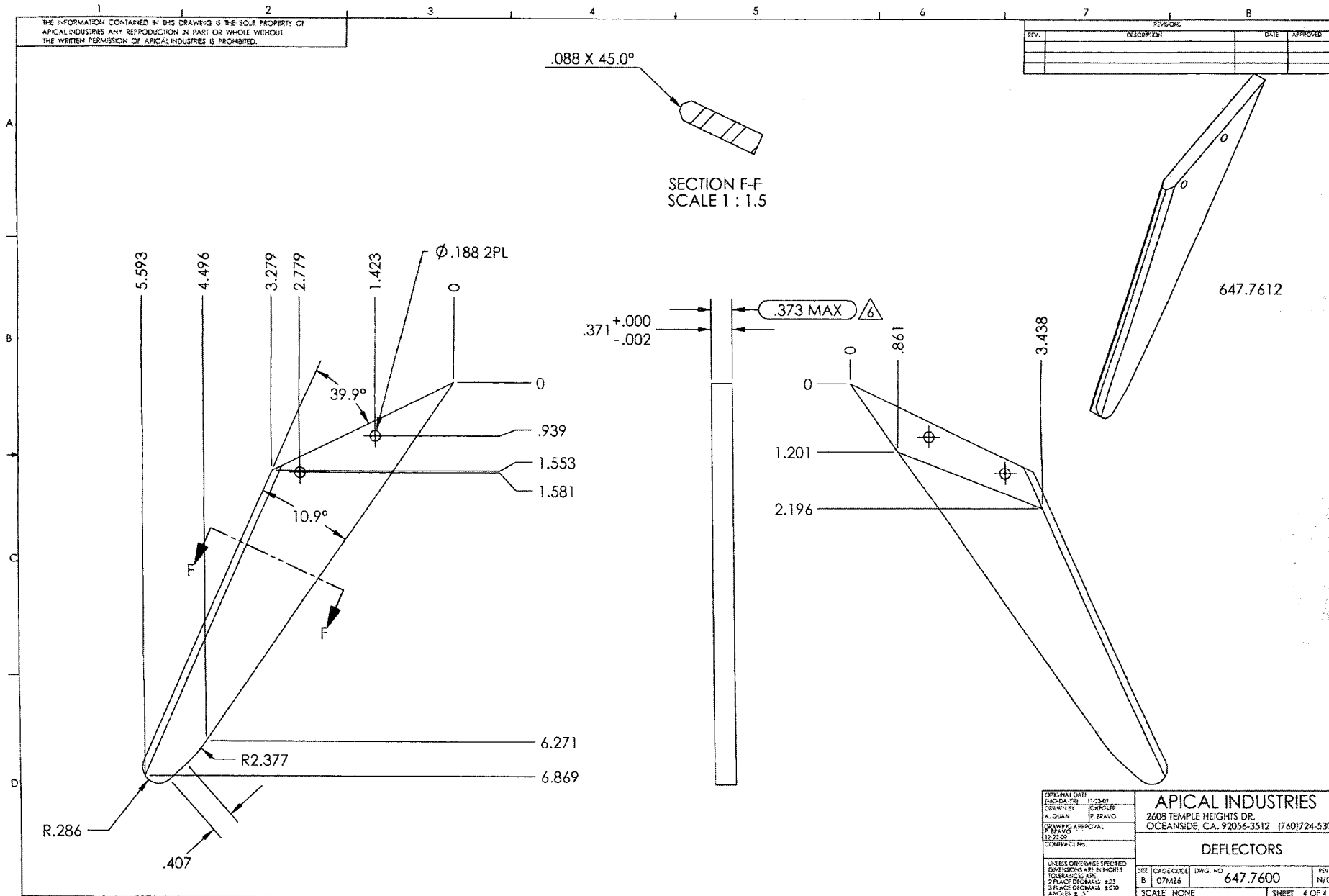
A/R	5	601.2045	RTV, LOCTITE 598		
2	4	601.3122	RIVET	MS20470AD6-14	
1	3	647.7612	BREAKAWAY TIP	△	△
1	2	647.7611	LOWER DEFLECTOR	△	△
	1	647.7610	UPPER DEFLECTOR	△	△△
△		647.7601	LOWER DEFLECTOR ASSY		△
7601	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY					
PARTS LIST					
NEXT ASSY (S)					
647.7400					
647.7500					
ORIGINAL DATE 11-20-09					
DRAWN BY: A. QUINN					
CHECKED BY: P. BRAYC					
DRAWING APPROVAL: P. BRAYC					
CONTRACT NO.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES					
TOLERANCES ARE:					
2 PLACE DECIMALS ±.02					
3 PLACE DECIMALS ±.030					
ANGLES ±.5°					
APICAL INDUSTRIES					
2608 TEMPLE HEIGHTS DR.					
OCEANSIDE, CA, 92056-3512 (760)724-5300					
DEFLECTORS					
SHEET 1 OF 4					
SCALE NONE					
REV. NO. 647.7600					
N/C					

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REV.	DESCRIPTION	DATE	APPROVED

.088 X 45.0°

SECTION F-F
SCALE 1:1.5



ORIGINAL DATE
INVOICE NO. 11-0000
DRAWN BY: J. GILBERT
A. GUAN P. BRAVO
DRAWING APPROVAL
P. BRAVO
12-22-02
CONTINUED TO:

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760) 724-5300

DEFLECTORS

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS: ±.03
3 PLACE DECIMALS: ±.010
ANGLES: ±.5°

SHEET	CAGE CODE	DWG. NO.	REV.
B	07M26	647.7600	N/C
SCALE NONE		SHEET 4 OF 4	